Page 1 May-13-13 1:09:32 PM Item ID: D3258-1 Accept Setup Start Revision ID: Stop Angle Bracket Item Name: **Start Qty: 12.00** Start Date: 5/16/13 Cust Item ID: Req'd Qty: 12.00 Required Date: 5/30/13 **Customer:** Reference: Run Date: 13-05-15 Tooling: Process Plan: __ML = Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Reject Tool# Reject Insp. Sequence ID/ Operation Set Up/ Tool ID Plan Accept Qty Work Center ID Description **Run Hours** Code Qty Number Stamp Draw Nbr Revision Nbr D3258 Rev A 100 0.00 FLOW WATER JET *100* 0.00 Waterjet Memo 1-Cut as per Dwg D3258 Dwg Rev: A Prog Rev: A 2-FLOW CNC Waterjet Deburr if necessary 304.063 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 0.00 OC Memo Quality Control

120

QC8- Inspect parts - second check

Memo

120 QC

Quality Control

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE					
												QA Closed:	Da	te:	
Work Orde	er.					DISPOSITION				AGAINST D	ЭΕI	PARTMENT,	/PROCESS		
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Part f	۷o.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is]	Therr	noforming	Finishing		Rec/Sto	e/Packaging	_	Other
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1		Bending				Bend		Grain				Ovalized			Pressure/Forced
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		Cracks			[Broken/Damaged		Inspect	ion Incomplete			Part Incorred	ct		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

150

Identify as per dwg & Stock Location: \$163\$ 0.00

150

Quality Control

Packaging Packaging Memo

0.00

25

13-8-2

										DQA:	Date:	
NCR: Y	es / No)			WORK ORDER NON-	COI	NFORM	ANCE / UP	DATE			
										QA Closed:	Date:	
Work Orde					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	" '
WOIK OIGE	a				Rework	1		Skid-tube	Crosstube	ן	Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing	•	re/Packaging	Other
NCR N	lo.				Work Order Update	1		Large Fab	Composite		Supplier	
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	Crushe	d/Crimped			Burrs	\perp	-	ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
:	Cuffs			L	Contamination		Mainte	nance	L	Part Moved		
	Heat T	reat		L	Countersink		Mislabe	led		Positioned V	_	-
	Inspec	tion Strip ir	n Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
,	Ripples	in Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord May-13-13 1:0		1595				595*							Page (3
Item ID: Revision ID: Item Name:	D3258-1 Angle Bracket	. = .		•	Accept	*N900	040	100)* s	•	Start Stop		S1*	
Start Date: Required Date Reference:	5/16/13	Start Qty: 12.00 Req'd Qty: 12.00		*12* *12*		Cust Item I Customer:	D:			_		14.		
Approvals:	Process Pla	in:	Date:	·	Tooling: SPC (Y/N):		nte:		F		itart Stop		R1* R2*	
Sequence ID/ Work Center	 ID	Operation Description	 -		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		leject lumber	Insp. Stamp	
¹⁶⁰ *1հՈ*		QC21- Final Inspection	- Work Orde	er Release	0.00				M	ヹ	13-0	15.8c	<u></u>	
QC		Memo			0.00				-					

Memo

Quality Control

											DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-O	COL	NFOR	MANCE / UPDATE		'	•	-	
											QA Closed:	Da	ate:	
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Part I	۷n					Scrap	1 1		Machining Small Fab	_	Pro	d. Eng. Coor.	-	Quality
, 5, 6, 6,	-					Use-as-is	1		noforming Finishing	\vdash	4	e/Packaging	\blacksquare	Other
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Root					Descri	ption of work order update		Initial	Action		Sign &			
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	╚	Bending				Bend	L	Grain		L	Ovalized		Ш	Pressure/Forced
	Щ°	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance		Temperature/Cure
	Шʻ	Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incorrec	t		Weld
	\Box	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/Mi	ssing		Wrong Stock Pulled
	\square	Cuffs				Contamination		Mainte	nance		Part Moved			
	[]	Heat Trea	it			Countersink		Mislabe	led		Positioned W	/rong		

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

May-13-13 1:09:32 PM

Work Order ID:

101595

Parent Item:

D3258-1

Parent Item Name:

Angle Bracket

Start Date: 5/16/13

Required Date: 5/30/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

B05.11.01Added Steps 6-7KJ/JLM IPP

. 	IPP Rev:C Now or	1 Waterj <u>et</u> 06-12-	13 JLM_								<u></u> .		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			110	sf	474.1714	0.005 — M	0.0631584 59 اطاق	 >_	-132_	13:08.11
				Location .		Loc Qty	<u>Lo</u>	c Code					10.00
				MAT020		474,1713688							
				1222	45	0.1713688							
				1231	36	140.8							
				1244	28	28.9							
				1245	72	48.3							
				1255	99	256				<u> </u>			

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: Work Order:	
Work Order:	
Part No. Scrap Skid-tube Crosstube Water Jet Engineering Use-as-is Use-as-is Large Fab Composite Supplier Skid-tube Crosstube Water Jet Engineering Finishing Rec/Store/Packaging Other	
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspect	or
Doc/Data	
Equip/Tooling	
Operator	
Material	
Setup	
Other	
Supplier Sup	

Landing Gear Ovalized Pressure/Forced Bend Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Cuffs Contamination Maintenance Positioned Wrong Countersink Mislabeled Heat Treat Other Inspection Strip in Tube Misread Power Loss/Surge **Cut Too Short** Ripples in Bend Drill Holes Offset Drawing Out of Calibration Torque Waves in Extrusion Out of Sequence Turning Sequence Finish Folio Outside Dimensions Wave/Twist in Tube

FAULT CATEGORY

General

Training Unapproved

DART AEROSPACE LTD	Work Order:	101595
Description: Angle Bracket,	Part Number:	D3258-1
Inspection Dwg: D3258 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.503	-		٧	JKM-01
1.050	+/-0.010	1.050	_		V	
0.250	+/-0.010	. 250	-		v	
0.202	+/-0.010	- 202			V	
1.454	+/-0.010	1.458	-		V	
Ø0.206	+0.005/-0.001	.205				
R0.125	+/-0.010	.125	-		RG	
		<u></u>				
	·					
					-	
			<u>. </u>			
						

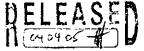
Measured by: Ae	Audited by:	Prototype Approval: N/A
Date: 13.08.11	Date: 13 8-12	Date: N/A

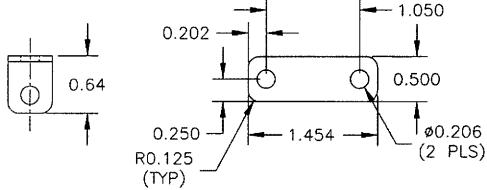
Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM	

a A 2		٠.	

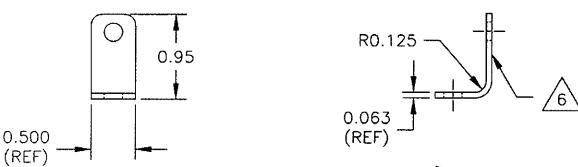


DESIGN	DRAWN BY	DART AEROS! HAWKESBURY, ONTA	
CHECKED	APPROYED -	DRAWING NO. D3258	REV. A SHEET 1 OF 1
DATE		TITLE	SCALE
04.01.27		ANGLE BRACKET	1:1
Α	04.01.27	NEW ISSUE	





D3258-1 FLAT PATTERN



D3258-1 ANGLE BRACKET



NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 to 0.015
- MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK (REF. DART SPEC. M304S16GA)
- FINISH: NONE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

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